



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SWA3-200
Job Sheet 192206



Part No: SWA3-200

Job Qty: 10 pcs

Part Name: Lower End



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA3-200 Rev 12 IPP Rev A 18.02.13 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	NLX 2500SY - 1	10 pcs	5/3/19	5/3/19	0.00	10.00	NLX 2500SY - 1		[Signature]
115	NLX 2500SY - B4B	10 pcs	5/3/19	5/3/19	0.00	10.00	NLX 2500SY - 1 - B4B		
120	QC 2	10 pcs	5/3/19	5/3/19	0.00	0.00	QC 2 - 1		[Signature]
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S169352



Part: SWA3-200

Job No: 192206

Serial No/Batch: S169352

Revision: 12

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/03/19

Plex 3/19/19 10:56 AM Dart.lajeunesse.marie

130 QC 8	10 pcs	5/3/19	0.00	0.00	QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 8 - 12	m/19/04/18
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
140 Packaging 3-1 - Stock - B4B	10 pcs	5/3/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS 28 9-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	

				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
150 QC 21 - SA	10 pcs	5/3/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	APR 18 2019 70
					QC 21 - SA - 53	9-89
Part Op 110 - Issue batch number Descriptions: 115 - NLX (MORI NLX 2500SY LATHE) 1-Machine as per DWG.FC301 FOLIO REV: <u>AA</u> DWG REV: <u>12</u> 2-Deburr 120 - QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Identify as per dwg & Stock Location: _____) 150 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M17-4-H1150-R1.500	17-4 SS Round Bar 1.500"	3.6000 ft (.36 ea)	110-NLX 2500SY - 1	5123953 57 1/2		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
110-NLX 2500SY - 1	M17-4-H1150-R1.500	4	6	0		
Part Specifications						
Specifications could not be found.						

Plex 3/19/19 10:56 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



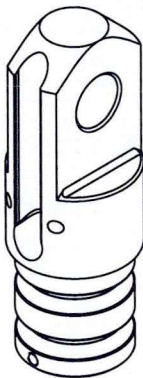
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

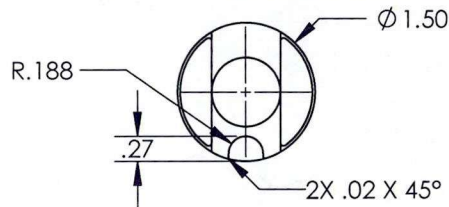
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

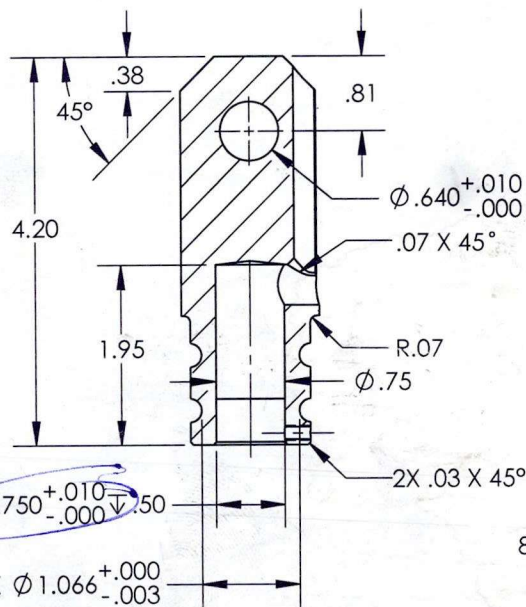
This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.



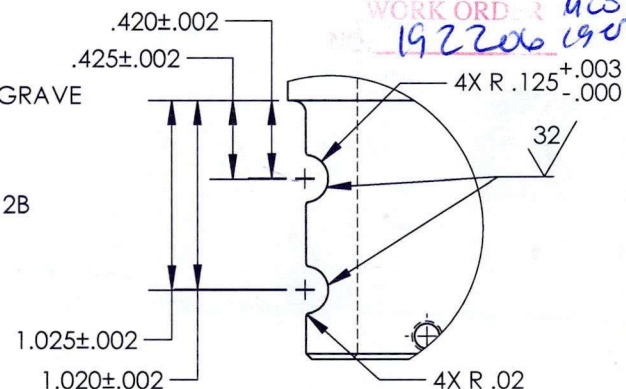
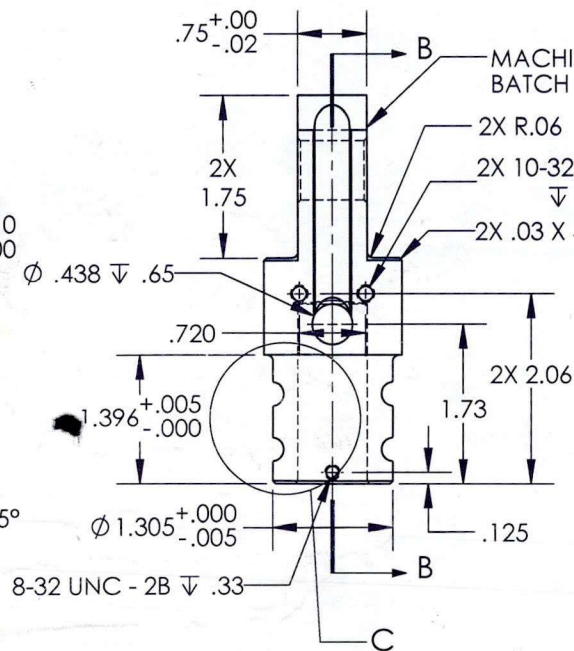
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		AS DRAWN BY CANAM	8/24/2012		
8		ADDED MISSING .750 DIM, ADDED DEPTH .500 TO Ø.750	11/14/2012	JAG	
9		DELETED .02 X 45° FROM TOP, ADDED DRILL POINT DETAIL AND (1.99) DIM.	8/6/2013	RJC	GE
10	16-0084	REMOVED DIMS .981, .976, .381, .376. ADDED DIMS .420±.002, .425±.002, 1.020±.002, 1.025±.002. CH'D DIM WAS 1.75 IS 2X 1.75, WAS Ø1.066±.000/-003 IS 2X Ø1.066±.000-.003, WAS .750 IS .75±.00/-02. CH'D MATERIAL, WAS S.S. 17-4 PH, IS S.S. 17-4 H1150/H1075.	7/18/2016	SM	JAG
11	17-0027	CH'D DIM'S WAS .375 IS .38, WAS Ø.750 ±.010/-000 Ψ.500 IS Ø.750 ±.010/-000 Ψ 1.95, WAS R.069 IS R.07, WAS 2X .030 X 45° IS 2X .03 X 45°, WAS 2X 10-32 UNF -2B Ψ.500 IS 2X 10-32 UNF -2B Ψ.50, WAS 8-32 UNC -2B Ψ.328 IS 8-32 UNC -2B Ψ.33, WAS 4X R.015 IS 4X R.02. DELETED DIM'S 1.95, Ø.750. ADDED NOTE MACHINE ENGRAVE BATCH #.	2/1/2017	RJC	JAG
12	17-0146	CH'D DIM WAS Ø.750 ±.010/-000 Ψ 1.95 IS Ø.750 ±.010/-000 Ψ.50. DELETED DIM (1.99). ADDED DIM'S 1.95, Ø.75.	6/20/2017	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER # 192206 1903-19



SECTION B-B



DETAIL C
SCALE 1 : 1

DART AEROSPACE	
TITLE LOWER END	
DWG NO. SWA3-200	REV 12
MATERIAL: S.S. 17-4, H1150/H1075	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
FRACTIONS ± 1/8	
ANGLES ± 5°	
SURFACES = 125	
SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CANAM	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
SCALE 1:2	DATE 5/16/2006
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			SWA3-200	1	LOWER END	S.S. 17-4, H1150/H1075		

DART AEROSPACE LTD		Work Order: 192 306
Description: Lower END		Part Number: SW A3-200
Inspection Dwg: SWA3-200		Rev: 12
Page 1 of 1		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	$\pm .01$	4.200	✓		Vern LPIID	
.38	$\pm .01$	.380				
45°	$\pm .5^\circ$	45°				
1.95	$\pm .01$	1.955				
Ø .750	$+ .01 / - .00$	.755				
Ø 1.066	$+ .000 / - .003$	1.065			112-197	
.03 x 45°	$\pm .01 \times .5^\circ$	.0349 x 45°			Vern LPIID	
Ø .75	$\pm .01$	.749				
R .07	$\pm .01$	.07			Rad gauge	
Ø .640	$+ .01 / - .00$	.644			Mic LPIID	
.81	$\pm .010$	.811			Mic LPIID	
R .188	$\pm .005$	.187			Rad gauge	
.27	$\pm .01$	.2695			H-gauge	
Ø 1.50	$\pm .01$	1.495			Vern LPIID	
.02 x 45°	$\pm .01 \times .5^\circ$	.028 x 45°				
.75	$+ .00 / - .02$	.740				
1.75	$\pm .01$	1.750				
Ø .438	$\pm .005$	.440				
.720	$\pm .005$	.722				
1.396	$\pm .005 / - .000$	1.396				
Ø 1.305	$+ .000 / - .005$	1.303				
8-32 UNF-2B	GO/NO GO	GO			GO/NO GO gauge	
.125	$\pm .005$	.125			Vern LPIID	
1.73	$\pm .01$	1.726			H-gauge	
2.06	$\pm .01$	2.055				
.03 x 45°	$\pm .01 \times .5^\circ$	.03 x 45°			Vern LPIID	
10-32 UNF-2B	GO/NO GO	GO			GO/NO GO gauge	
.50	$\pm .010$	.50			Vern LPIID	

Measured by: [Signature]	Checked by: [Signature]	QC Inspector:
Date: 1904-07	Date: 19/04/18	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

